

Thursday, 3/22/2007 1:45:01 PM  
Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT TUBE ASSEMBLY  
 Job Number : 31440  
 Estimate Number : 10699  
 P.O. Number : N/A Part Number : D3391025  
 This Issue : 3/22/2007 S.O. No. : N/A Drawing Number : D3391 REV F  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : F  
 Previous Run : 31321 Material : N/A  
 Due Date : 4/10/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : J.D. 07.03.02  
 Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC  
 Est Rev: C 06-03-28 Update Manufacturing Instructions  
 JLM  
 est rev D 07.03.20 revF dwg ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D6014090 ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion 26546

Identify as D3391-3

M8 07/04/01

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: F & Dwg D3391 Rev: F

M8 07/04/01

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 07/04/02

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: F

2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

3-Deburr

N/A 07.04.03  
 07/04/03 (71)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/22/2007 1:45:01 PM  
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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 31440

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 02/04/03 (1)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S.F 07/04/09 (1)

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

EL 7/4/10

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-4-10

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

4-C'sink holes for float bag (4 holes per side)-as per Dwg D3391

5-Debur

DP 7-4-10

DP 7-4-11

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

For 200

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

07/04/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 31440

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

POWDER COATING

POWDER COATING



M103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MS

07-04-23

(1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(1)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-f

07/04/23

14.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Aft Cap

Pick:

Qty

Part Number

Description Batch

1

D2646

Aft Cap

B20119

15.0

D35371

WEARPAD



B31998



\*

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPAD

~~B30757~~

16.0

D35377

Wearpad



B31911



\*

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearpad

~~B30758~~ B31401

17.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

B31400

18.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

B31402

19.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Insert

Pick:

Qty

Part Number

Description

Batch

FL

07/04/23 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 31440

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description:

14 AECS10KB366 Insert

m104192.

20.0

AECS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AECS10KB316 Insert  
or NAS1330C3KB316

m17905

21.0

AECS10KB266

INSERT



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AECS10KB266 Insert  
or NAS1330C3KB266

m17905

22.0

NAS1330C3KB166

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

8 NAS1330C3KB166 Insert

m103278

23.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C4A Bolt

m103691

24.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

m103481

07/04/230

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 31440

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	m103641

26.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	m103641

SL 07/04/23 ①

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-2411-291

Sikaflex expiry date: 07/10

m103561

SL

07/04/23 ①

28.0

QC5

INSPECT WORK TO CURRENT STEP



Inspected inserts 2070423



Comment: INSPECT WORK TO CURRENT STEP

2070501

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

PRP 30363

07/05/11 SL

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20710511

Job Completion:



U 07/05/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	31440
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b>	D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> F # 07.02.22	<b>Page 1 of 1</b>	

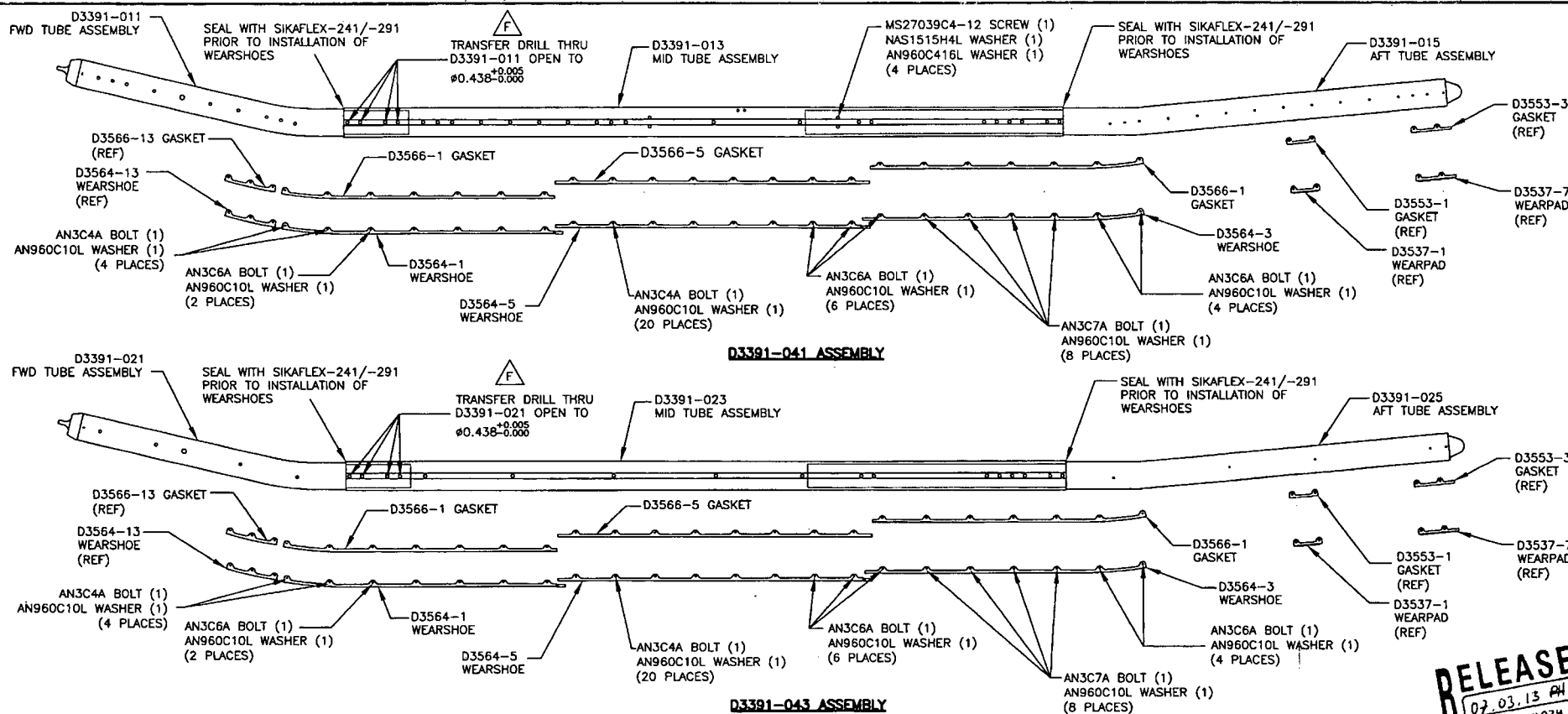
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.500	✓			
88.93	+/-0.030	88.93	✓			
44.995	+/-0.030	45.000	✓			
3.200	+/-0.010	3.201	✓			
1.526	+0.000/-0.030	1.526	✓			
0.200	+/-0.010	0.201	✓			
7.500	+/-0.010	7.498	✓			
27.750	+/-0.010	27.750	✓		Tape measure	
31.750	+/-0.010	31.750	✓		Tape measure	
35.250	+/-0.010	35.250	✓		Tape measure	
<del>0.400</del>	<del>+/-0.010</del>	<i>07-04-23</i>				
<del>00.208</del>	<del>+0.005/-0.001</del>					
3.300	+/-0.010	3.300/3.309	✓			
0.200	+/-0.010	0.201	✓			
3.520	+/-0.010	3.520	✓			
0.687	+0.010/-0.000	0.687	✓			
R0.062	+/-0.010	0.062	✓		R-4	
Ø0.484	+0.005/-0.001	0.486	✓			

<b>Measured by:</b>	MS	<b>Audited by:</b>	SV	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/04/22	<b>Date:</b>	07/04/21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	



# D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER

## GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (0.250-0.257) FOR WEARSHOE INSERTS. C'SINK 0.391/0.425 x 100" AS APPLICABLE AND INSTALL INSERTS IN LOCATIONS WHERE INDICATED.

NO. 31410  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
CONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

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F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.01.18	TITLE
		412 FLOAT SKIDTUBE
		SCALE
		NTS

DART DART AEROSPACE USA, INC.

PORT HADLOCK, WA

DRAWING NO. 07.03.13 PH

REV. F

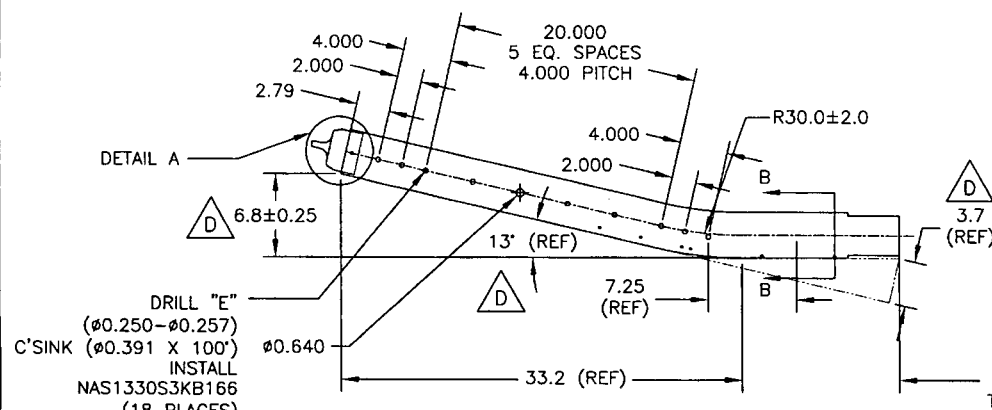
SHEET 1 OF 5

SCALE

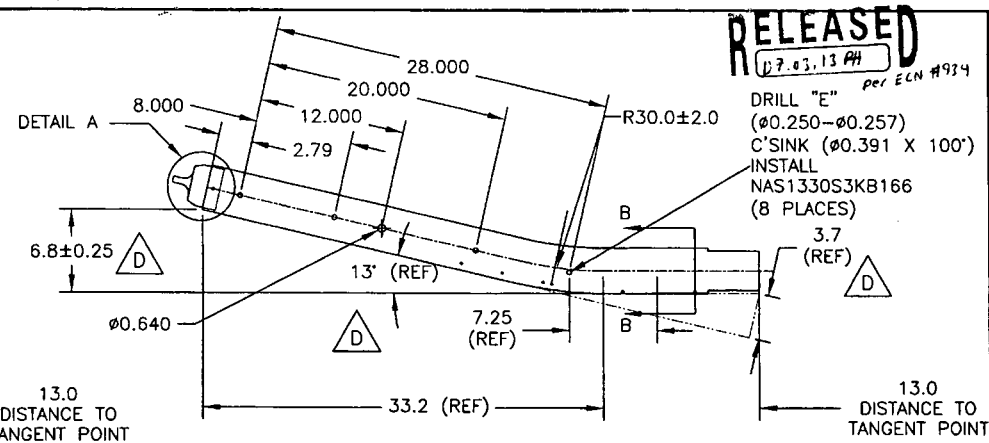
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07.03.13 PH  
per E-N #934

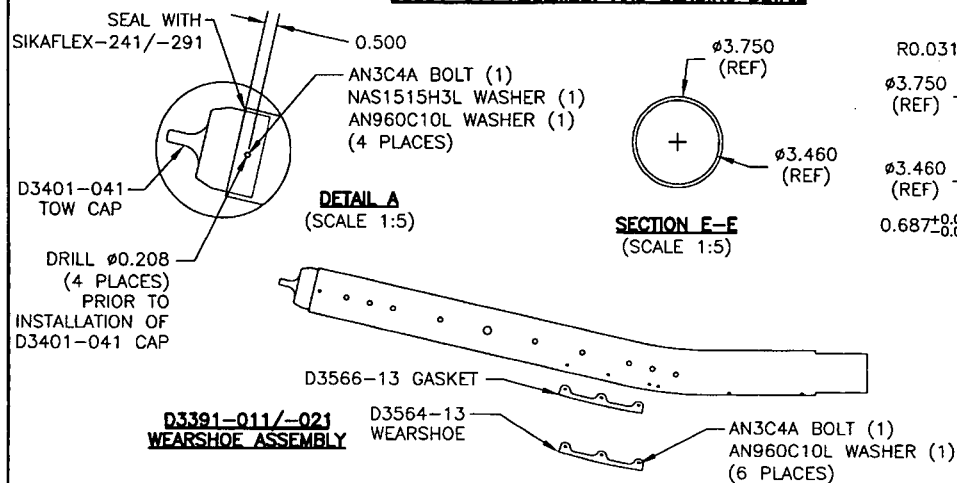
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 D7.03.13 AH  
 per ECN #974



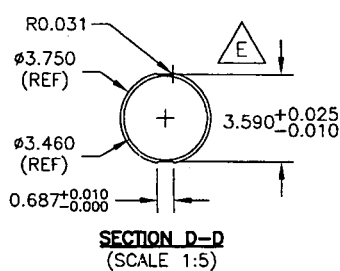
**D3391-011 ASSEMBLY AND BENDING DETAIL**



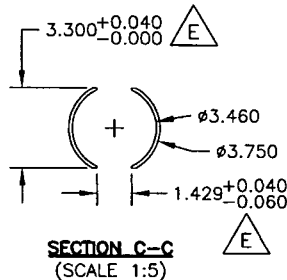
**D3391-021 ASSEMBLY AND BENDING DETAIL**



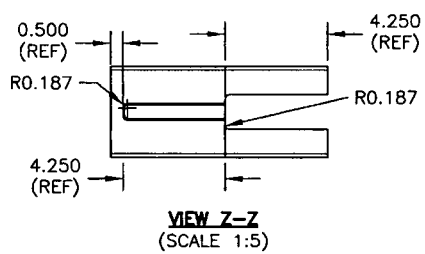
**D3391-011/-021 WEARSHOE ASSEMBLY**



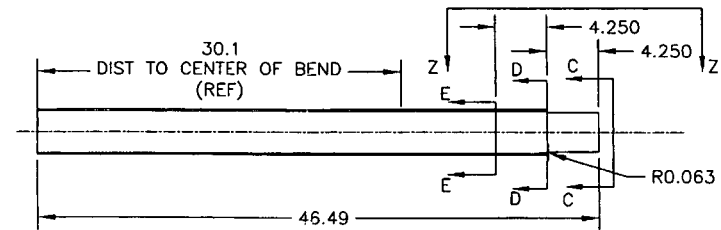
**SECTION D-D (SCALE 1:5)**



**SECTION C-C (SCALE 1:5)**



**VIEW Z-Z (SCALE 1:5)**



**D3391-1 DRILLING AND CUTTING DETAIL (MAKE FROM D6013-047 SKIDTUBE MATERIAL)**

**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

5  
 DRILL "E"  
 (Ø0.250-Ø0.257)  
 C'SINK (Ø0.391 X 100")  
 INSTALL  
 NAS1330S3KB166  
 (12 PLACES)

UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE

NO. 31440  
 WORK ORDER  
 RETURN TO  
 SHOP COPY  
 ENGINEERING

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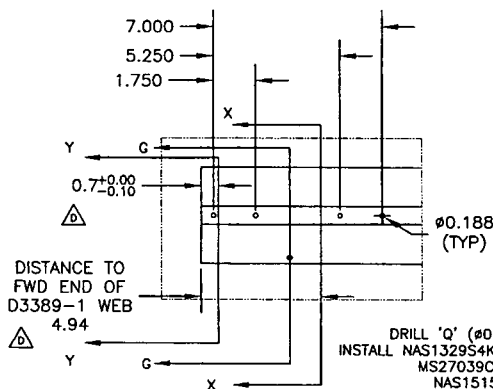
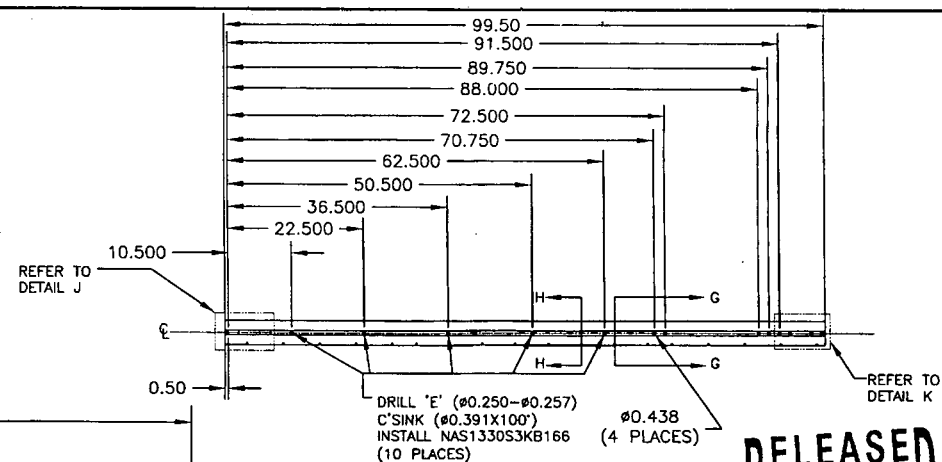
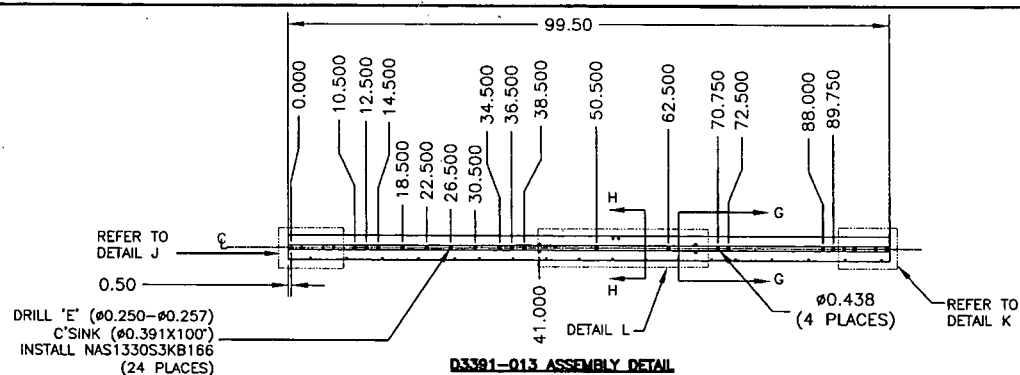
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 APPROVED: PH

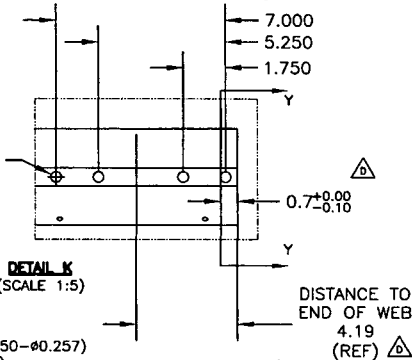
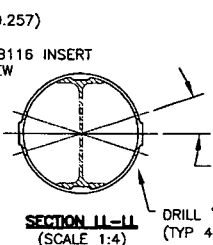
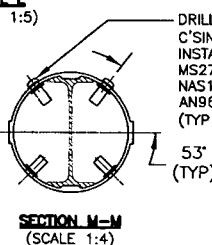
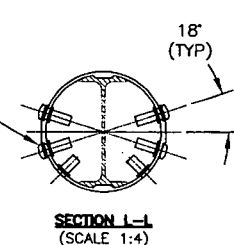
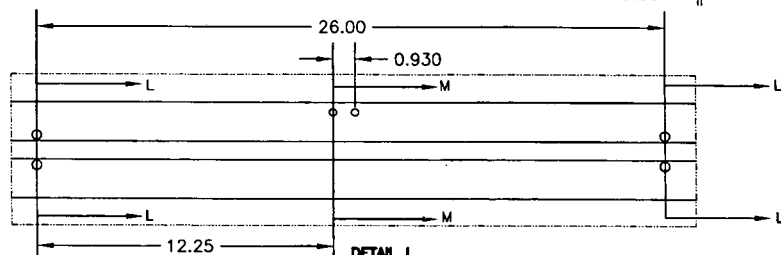
**DART** DART AEROSPACE USA, INC.  
 PORT HADLOCK, MA

DRAWING NO.: D3391  
 TITLE: 412 FLOAT SKIDTUBE

REV. F  
 SHEET 2 OF 5  
 SCALE: 1:10



DRILL 'Q' (#0.332-#0.338)  
INSTALL NAS132954KB140 INSERT  
MS27039C4-08 SCREW  
NAS1515H4L WASHER  
AN960C416L WASHER  
(TYP 4 PLACES)



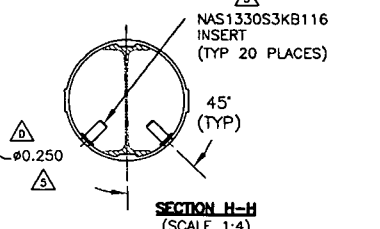
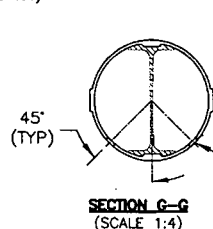
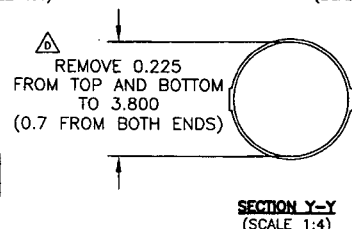
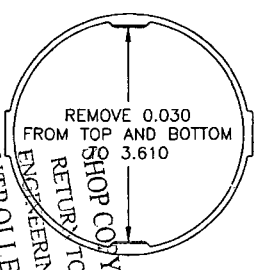
# D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS132954KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

## D3391-013/-023 MID TUBE ASSEMBLY

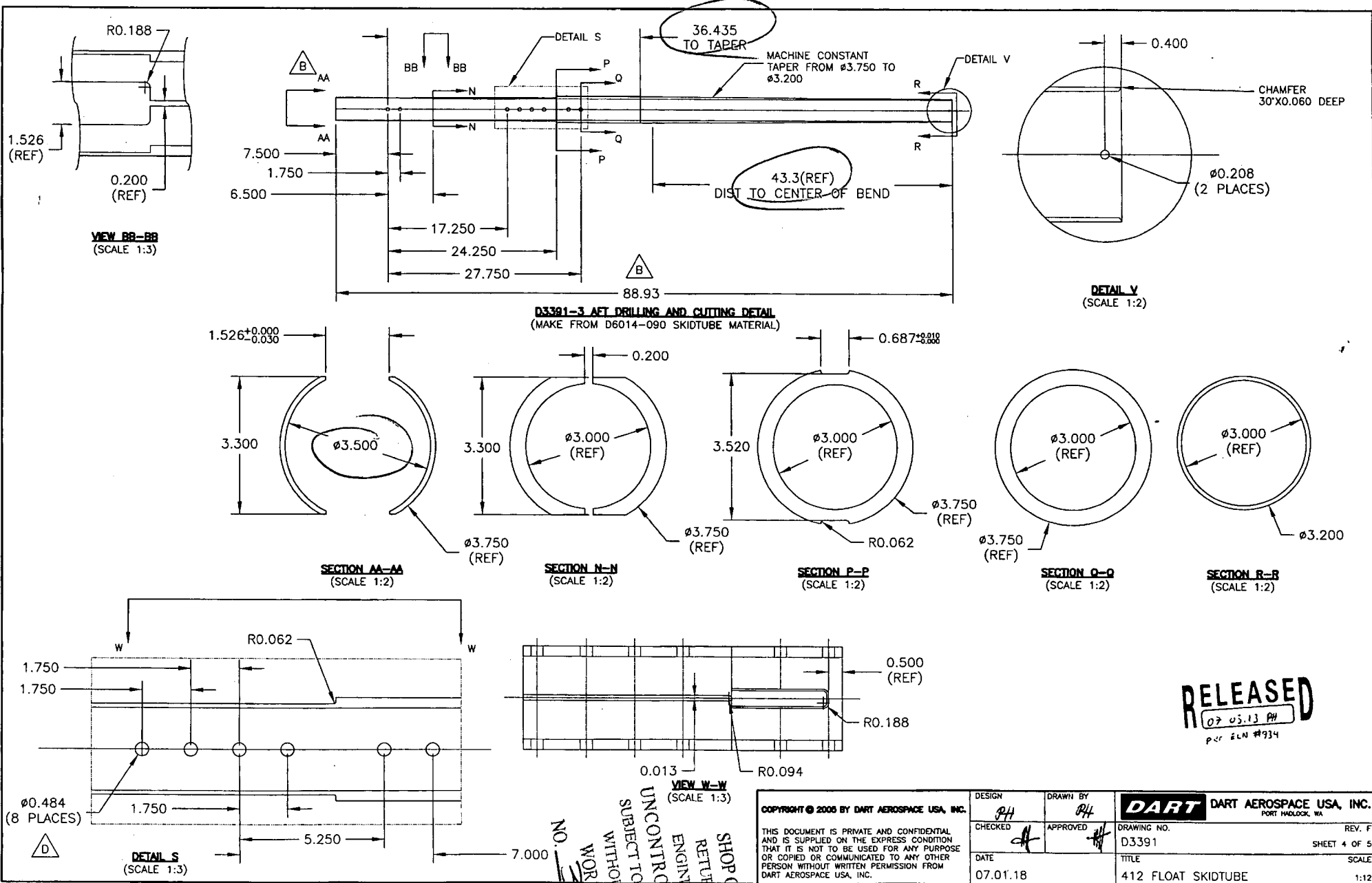
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QS 015

WORK ORDER  
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WITHOUT NOTICE



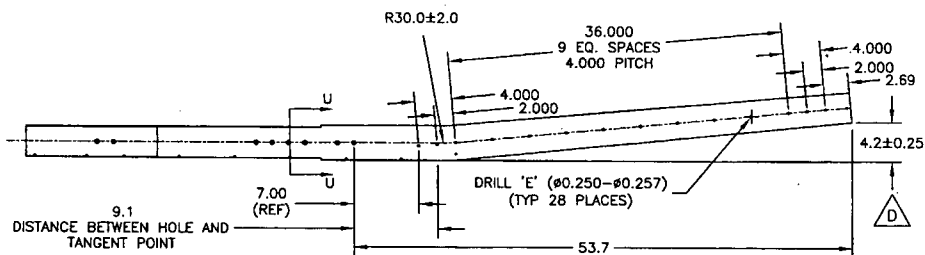
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CHECKED H	APPROVED H	DRAWING NO. D3391		
DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		REV. F SHEET 3 OF 5 SCALE 1:20

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07.05.13 RH  
Per ECU #934

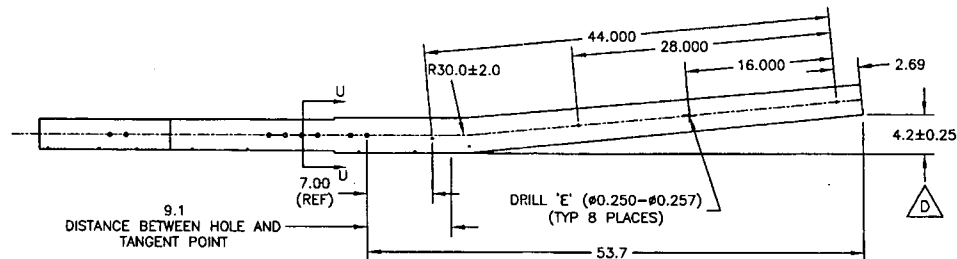


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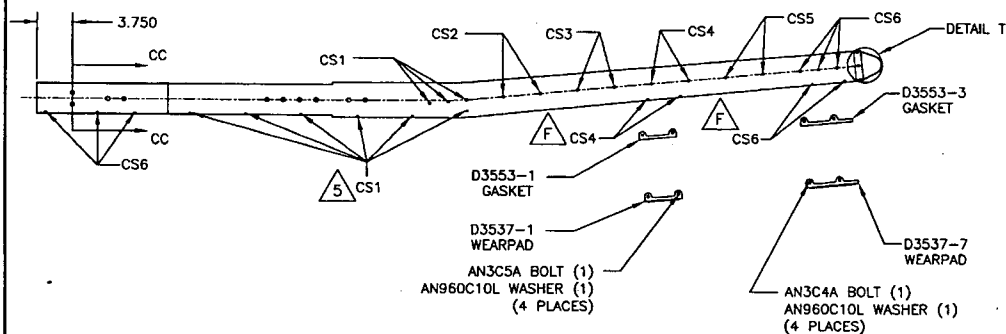
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DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		SCALE 1:12	



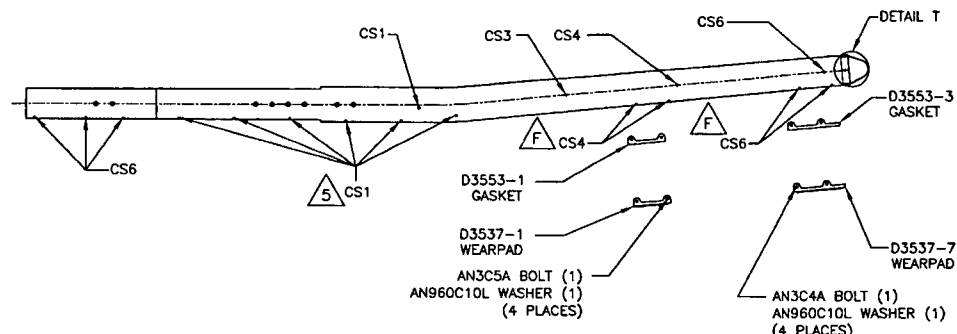
**D3391-015 BENDING AND ASSEMBLY DETAIL**



**D3391-025 BENDING AND ASSEMBLY DETAIL**



**D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)



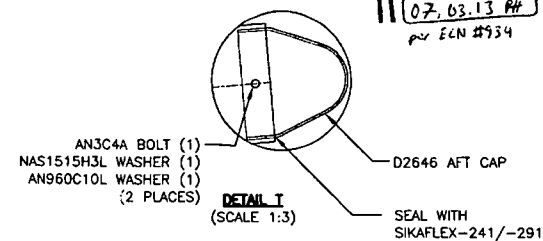
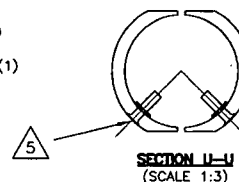
**D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)

**D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST**

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4	4	NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4	4	NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

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SECTION CC-CC  
(SCALE 1:3)

DRILL 'Q' (#0.332-#0.338)  
C'SINK (#0.529X100")  
NAS1330S4KB151 INSERT (1)  
(4 PLACES)



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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Chap. 2